

Ship Aug 30

Work Order ID 73059

Thursday, August 25, 2011 7:01:42 AM



Page 1

Item ID: D2330-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 8/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/31/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2330

Rev H

100

0.00



Large Fab

Memo

0.00

Large Fab

1- weld as per dwg D2330 and QSI 004

S.S Rod batch: 117884

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11.08.30

BE
11.08.30

8/30

HL

Work Order ID 73059

Thursday, August 25, 2011 7:01:42 AM



Page 2

Item ID: D2330-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Base Assembly

Start Date: 8/25/2011 Start Qty: 1.00



Required Date: 8/31/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1X ~~Q~~ M-11/08/30

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

Start Time:

Oven Temperature:

Finish Time:

8:15
400°F
8:45

1X ~~Q~~ M-11/08/31

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 - BR 11-8-31

Work Order ID 73059

Thursday, August 25, 2011 7:01:42 AM

Page 3

Item ID: D2330-041

Accept

Revision ID:

Item Name: Basket Base Assembly

Start Date: 8/25/2011 Start Qty: 1.00

Required Date: 8/31/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: *GA*

0.00

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

*JS 11/08/31 (C)**11/8/31 JF**MP 11-08-31*

Picklist Print

Thursday, August 25, 2011 7:00:07 AM

Page 1

Work Order ID: 73059

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 8/25/2011

Required Date: 8/31/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H 02.09.04 IM304EX0.75-16F was M750-16FXS-S/S KJ
IPP Rev: I 08-09-09 revF as per dwg (ecn 08-522) DD verF by: EC
IPP REV: J 10.11.30 AS PER DWG REV.H DD VERF: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2012-107



Clevis

Manufactured

No

100

Each

29.0000

1

1



PL 11.08.29

Location

Loc Qty

Loc Code

ST004

21

71602

21

WA005

8

66811

8

D2235-1



Basket Rib

Manufactured

No

100

Each

6.0000

4

4



SAD

11-08-25

Location

Loc Qty

Loc Code

WA005

6

66895

4

71940

2

D2252-1



Frame

Manufactured

No

100

Each

12.0000

2

2



11.08.25

Location

Loc Qty

Loc Code

WA006

12

51941

4

58084

8

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 7:00:08 AM

Page 2

Work Order ID: 73059

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 8/25/2011

Required Date: 8/31/2011

Start Qty: 1.00

Required Qty: 1.00

D2252-7
Frame
Manufactured No

73080 ①

4.0000 1 1



11.08.25

Location Loc Qty Loc Code

WA 4
70970 4

D2253-1
Lug
Manufactured No

100 Each 17.0000 2 2



11.08.25

Location Loc Qty Loc Code

WA005 17
53965 17

D2254
Gussett
Manufactured No

100 Each 48.0000 2 2



11.08.25

Location Loc Qty Loc Code

WA005 48
39801 48

D2327-3
Spacer Bushing
Manufactured No

100 Each 22.0000 1 1



11.08.25

Location Loc Qty Loc Code

WA 22
71971 3
72296 19

D2330-1
Frame
Manufactured No

100 Each 0.0000 2 2



B73066 ②

11.08.25

Thursday, August 25, 2011 7:00:08 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 7:00:08 AM

Page 3

Work Order ID: 73059

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

Start Date: 8/25/2011

Required Date: 8/31/2011

Start Qty: 1.00

Required Qty: 1.00



Frame

Manufactured No

B73057 100

① Each

0.0000



1

11.08.25



Frame

Manufactured No

100

Each

2.0000



1

11.08.25

Location

Loc Qty

Loc Code

WA

67335

2

2

②



Mounting Bracket

Manufactured No

100

Each

33.0000



4

4

11.08.25

Location

Loc Qty

Loc Code

WA

69258

33

26

69739

2

70766

5

③



Hinge Half

Manufactured No

100

Each

8.0000



3

3

11.08.29

Location

Loc Qty

Loc Code

WA

68884

8

8

③

Thursday, August 25, 2011 7:00:09 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, August 25, 2011 7:00:09 AM

Work Order ID: 73059

Parent Item: D2330-041

Parent Item Name: Basket Base Assembly

M304EX0.75-16F

Purchased

No

100

sf



Expanded Metal Flat SS



Start Date: 8/25/2011

Required Date: 8/31/2011

Start Qty: 1.00

Required Qty: 1.00

918.8851

30

30



Pl 11.08.30

Location

Loc Qty

Loc Code

WA

918.885055

115012

95

117197

102.9036

117455

16.0341

117896

53.3264

118153

98.6394

118248

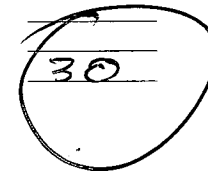
33.0983

118450

199.883255

118597

320



Thursday, August 25, 2011 7:00:09 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2330-041	BASKET ASSEMBLY
3		X	D2330-043	LID ASSEMBLY
7	1		D2012-107	CLEVIS
8	4		D2235-1	RIB
9	2	2	D2252-1	FRAME
10	1	4	D2252-7	FRAME
11	2		D2253-1	LUG
12	2		D2254	GUSSET
13	1	1	D2327-3	BUSHING
14		1	D2329	LABEL PLATE
15	2	2	D2330-1	FRAME
16	1		D2330-5	FRAME
17	1		D2330-7	FRAME
18		1	D2330-15	FRAME
19	4	2	D2581	MOUNTING CHANNEL
20	3		D3748-1	HINGE HALF
21		3	D3749-1	HINGE HALF

RELEASED
2010-11-25

NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF: DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF: DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

H	DIM 0.50 WAS 0.75 (ZN D2-3 & D6-3) REF NCR 10-346	JPH	10.09.28
G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 20 AND 21 REPLACE D2232-1/-3; STRETCHED LID FROM 83.27" TO 84.00"; ITEMS 9 & 10 REPLACE D2330-3/-9/-13; ITEM 13 (ON LID) REPLACES D2327-1; REORGANIZED ALL SECTION & DETAIL VIEWS. REASON: SEE PAR#09-006.	MB	09.02.05
F	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 6 ADDED. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1. D2253-1 WAS D2253 (NCR 533).	KE	05.11.10
D	MODIFIED LATCH, REDRAWN	KE	99.09.14
C	ADDED LATCH AND LABEL PLATE	BK	96.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	J		
CHECKED	J	DRAWING NO.	REV. H
MFG. APPR.	J	D2330	SHEET 1 OF 6
APPROVED	J	TITLE	SCALE
DE APPR.	J	BASKET ASSEMBLY (206B)	NTS
DATE	10.09.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR FORWARDED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

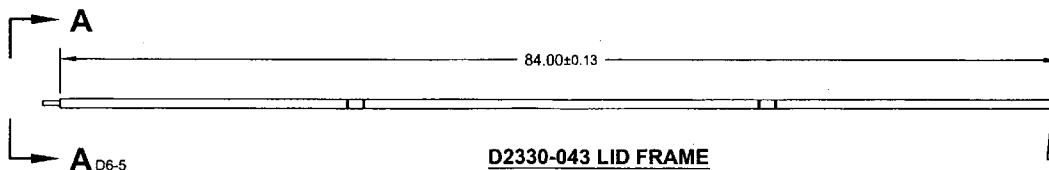
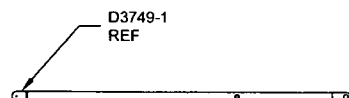
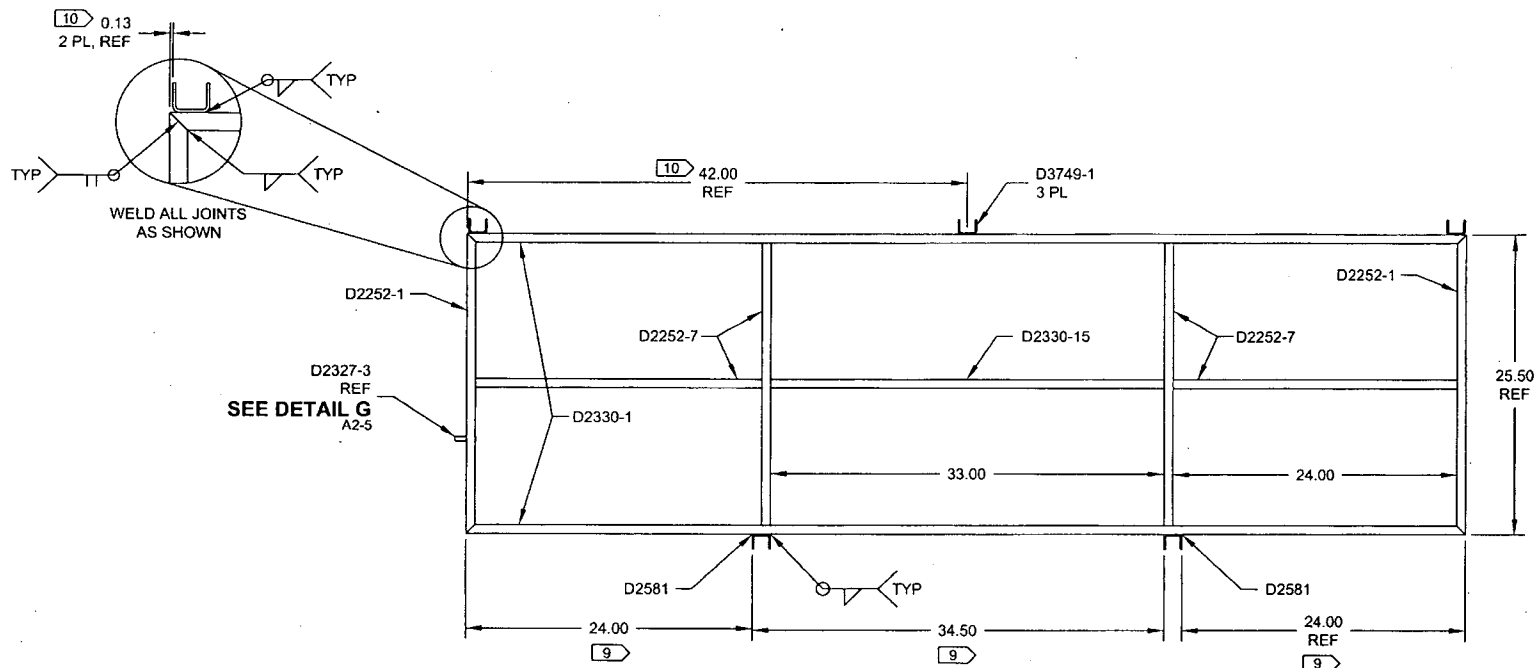
8 7 6 5 4 3 2 1

D

C

B

A







D2330-043 LID FRAME

LID FRAME NOTES:

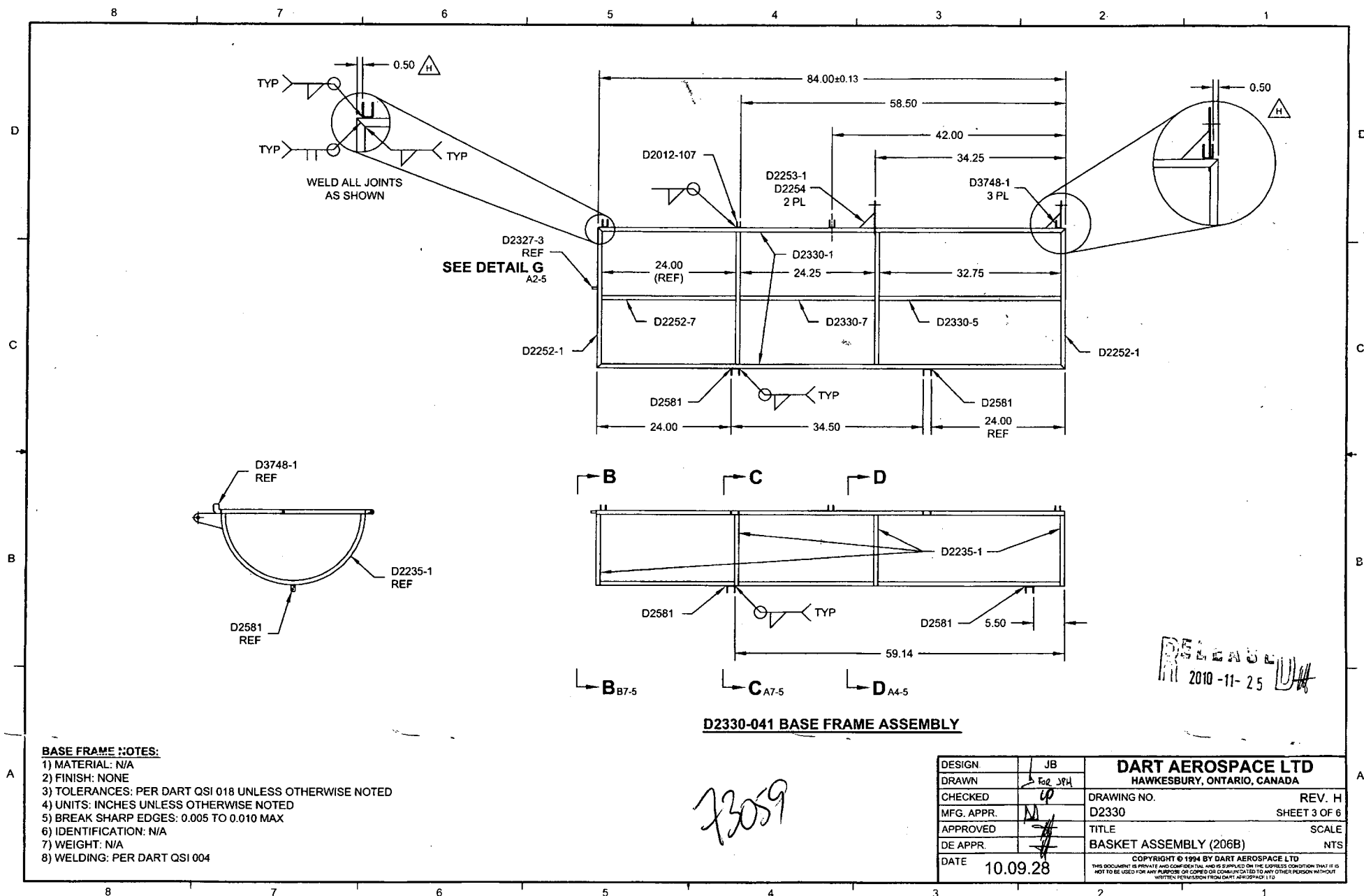
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2330-041 BASKET BASE ASSEMBLY

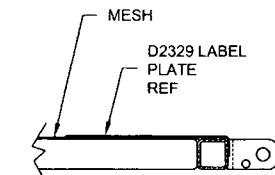
13059

RELEASED
2010-11-25

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG APPR.		D2330	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206B)	NTS
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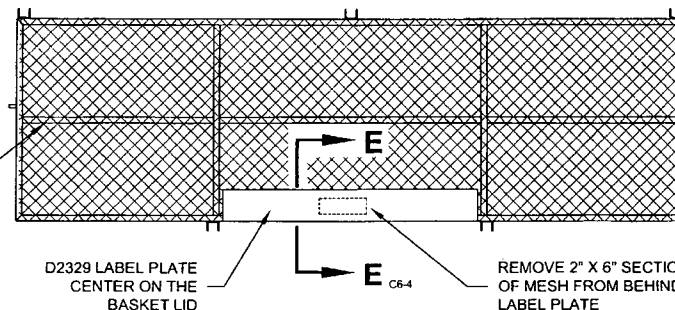
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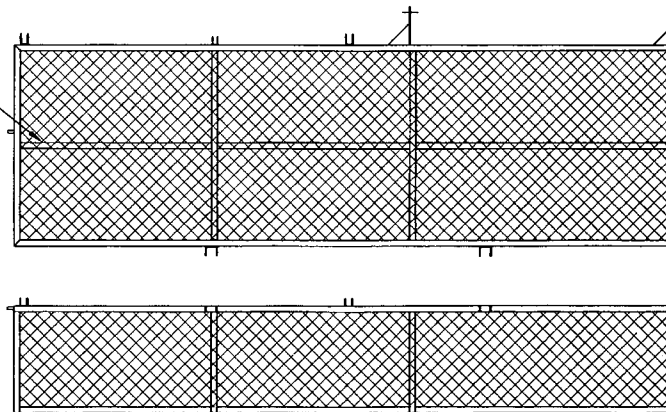


SECTION E-E C3-4
VIEW ROTATED 90° CCW

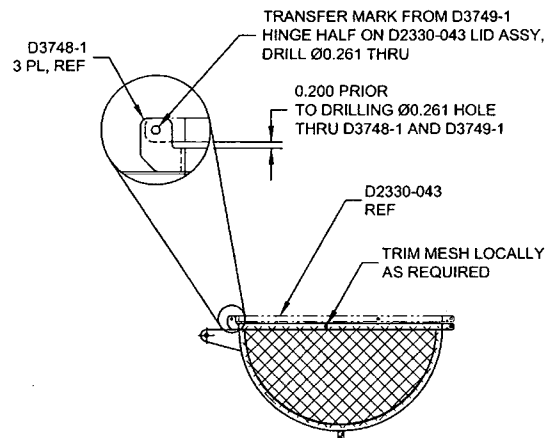
TACK WELD EACH
STRAND END OF
MESH TO FRAME



D2330-043 LID ASSEMBLY



D2330-041 BASE ASSEMBLY





ASSEMBLY NOTES:

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

RELEASED
2010-11-25

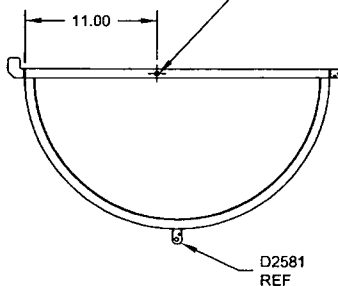
73059

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 4 OF 6
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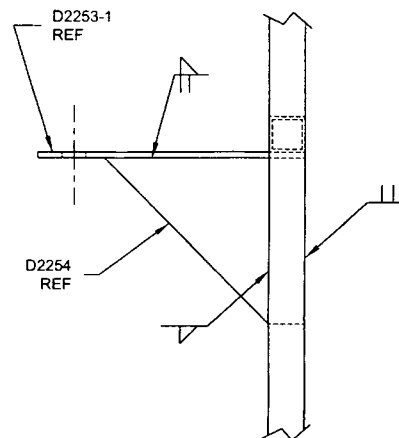


VIEW A-A A6-2

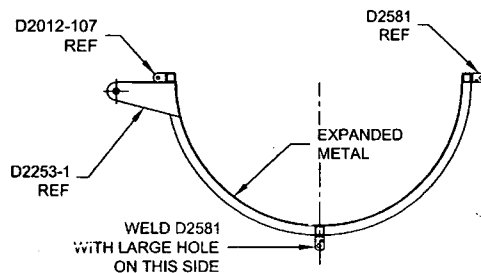
DRILL 3/8 HOLE AND
INSTALL D2327-3
SEE DETAIL G A2-5



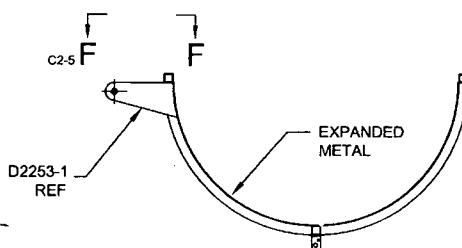
VIEW B-B A5-3



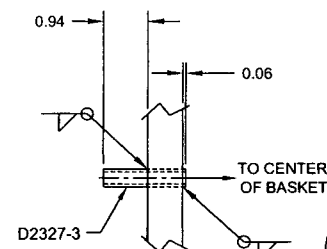
VIEW F-F B6-5
SCALE 4X



SECTION C-C A4-3



SECTION D-D A3-3



DETAIL G
SPACER INSTALLATION
SCALE 4X

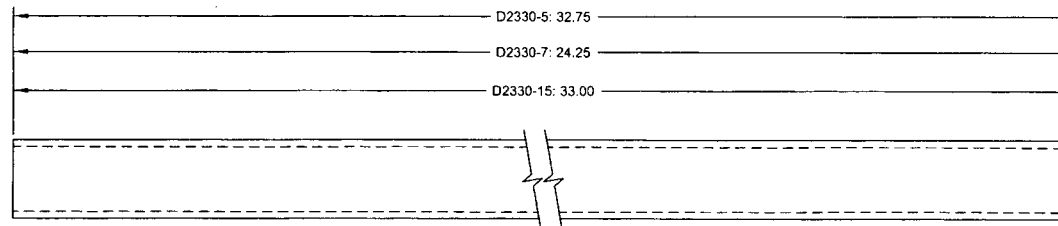
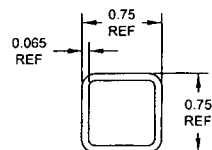
RELEASED
2010-11-25

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	A. J. P. H.	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. H
MFG. APPR.	JP	D2330	SHEET 5 OF 6
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BASKET ASSEMBLY (206B)	NTS
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73059

8 7 6 5 4 3 2 1

D

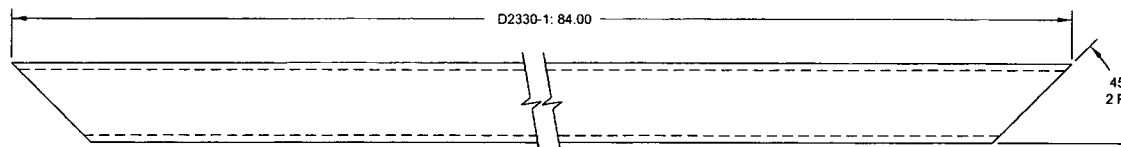
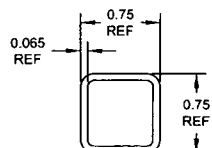


D2330-5 FRAME

D2330-7 FRAME

D2330-15 FRAME

C



D2330-1 FRAME

B






A

NOTES:

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

73059

RELEASED
2010-11-25

DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2330	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1